



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
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Tel (613) 632-5200
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D212-664-201
Job Sheet 182139



Part No: D212-664-201

Job Qty: 1 ea

Part Name: Aft Crosstube - High



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/17/18

Job Tracking No:

Due Date: 9/7/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: IIN-D212-664 REV.J/ D212-664-241 REV E IPP Rev:E 04.02.16 Reformat K/DS IPP Rev:F 06-03-29 Remove Coments on Pick List JLM IPP Rev:G 07-04-30 As per Rev C JLM IPP Rev:H 08-05-22 up date Qty of rubber cushion DD verf:EC IPP REV:I 14.05.27 AS PER ECN14-570 DD VERF:JLM

Ship Via:

6825

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	9/7/18	9/7/18	0.00	0.00	Start Up Crosstubes-1		DPZ 11/08/18
110	Packaging	1 pcs	9/7/18	9/7/18	0.00	0.00	Packaging1-3		DPZ " "
120	CNC Bend Crosstubes	1 pcs	9/7/18	9/7/18	0.00	4.44	CNC Bend Crosstube		DPZ " "
130	QC	1 pcs	9/7/18	9/7/18	0.00	0.00	QC15		38
140	Crosstubes	1 pcs	9/7/18	9/7/18	0.00	4.99	Crosstubes-1		DPZ 11/08/18
150	HandFXtube	1 pcs	9/7/18	9/7/18	0.00	1.25	HandFinish5		DPZ 11/08/18
160	QC	1 pcs	9/7/18	9/7/18	0.00	0.00	QC7-1		38 DAS
170	QC	1 pcs	9/7/18	9/7/18	0.00	0.00	QC5		9-89 38
180	Outsource	1 pcs	9/7/18	9/7/18			SKY002-VC	5	DPZ 11-19
190	Packaging	1 pcs	9/7/18	9/7/18	0.00	0.00	Packaging2		NOV 23 2018
200	QC	1 pcs	9/7/18	9/7/18	0.00	0.00	QC5		38
210	SprayPaint	1 pcs	9/7/18	9/7/18	0.00	1.47	Spray Paint		AB 11-22
220	QC	1 pcs	9/7/18	9/7/18	0.00	0.00	QC14		38
230	Crosstubes	1 pcs	9/7/18	9/7/18	0.00	1.47	Crosstube		AB 11-27
240	QC	1 pcs	9/7/18	9/7/18	0.00	0.00	QC5		38
250	Packaging	1 pcs	9/7/18	9/7/18	0.00	0.00	Packaging1-3		DAS 69
260	QC	1 pcs	9/7/18	9/7/18	0.00	0.00	QC4		DAS 69
270	Packaging	1 pcs	9/7/18	9/7/18	0.00	0.00	Packaging3-1		9-89 69
275	DC	1 pcs	9/7/18	9/7/18	0.00	0.00	DC		9-89 21
280	QC21-FG	1 Ea	9/7/18	9/7/18	0.00	0.00	QC21		DAS DEC 0 3 2018

Part Op 120 - ***VERF SET-UP BEFORE BENDING BY: *** Bend tube as per Dwg D212-664-241 using Descriptions: CNC bender program 212-aft

140 - 1-Drill pilot holes in tube as per Dwg D212-664-241 using drill Jig DT8550, DT8551, drill table DT8577 and locate tower holes #8 as per QSI0010. 2-Ream hole to finish size in tube as per Dwg D212-664-241 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes. 3-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-241 4- ***WEAR LATEX GLOVES HANDLIND CROSSTUBE. *** Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241

150 - ***IMMEDIATELY AFTER GRINDING***

180 - ***WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE. *** Issue P/O: 041806 LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2

190 - ***WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE. ***

200 - ***WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE. *** Inspect for damage & ensure results are as per Dwg D212-664-241

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Past Expiry Date ☐	Manufacturing Process ☐																								
Misidentified ☐	Past Due ☐	OTHER :																							

210 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***Primer 138962/Clear 138875/Paint 138836
 220 - Then, Wrap in plastic bag to protect from scratches
 230 - *****LAY DOWN CORSTUBE ON TABLE AND PUT DT10302 PINS IN SADDLE HOLE FACING UP, USE HOLE IN TAPE MESURE TO PUT IN PINS FOR LOCATING CENTER OF CROSSTUBE. ***** 1- Abrade mating surfaces of support and crosstube with 180 grit sandpaper, clean the area with MEK or equivalent as per dwg 2- Install supports with Proseal 890 per D212-664-241 and QSI 015 A/R Proseal 890 Batch: 5096394 EXP: 3/19
 PROSEAL CURE TIME 72 HOURS: Start: 18-11-27 Finish: 18-11-30 3- Install clamps with rubber cushion (ENSURE CLAMPS ARE INSTALL ON TOP SIDE OF CROSSTUBE) using DT9565 as per Dwg D212-664-241. ***Torque all clamps to 80-100 IN-LBS.***
 240 - ***RE-CHECK TORCQUE ON CLAMP AFTER PROSEAL HAS CURED FOR 72HOURS AS PER DWG.***
 260 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____
 270 - Identify and pack for shipping as per PPP D212-664-201 Location : FG098
 275 - Photocopy bluefile and create labels as per PPP D212-664-201 CHG006

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D212-664-201TRN	Crosstube Turning Detail	1 Ea (1 ea)	90-Start up Operation	<u>5127702</u>
D2940-1	Support	2 Ea (2 ea)	230-Crosstubes	
D3595-063-530	Rubber Cushion 0.63" Wide X 5.30" Long	4 Ea (4 ea)	230-Crosstubes	
MS21920-28	Clamp	4 Ea (4 ea)	230-Crosstubes	
AN6-40A	3/8-24 Bolt X 3" Long	4 Ea (4 ea)	250-Packaging	<u>5041008</u>
AN6-41A	Bolt	2 Ea (2 ea)	250-Packaging	<u>5045894</u>
D3428-1	Placard	1 Ea (1 ea)	250-Packaging	<u>5087521</u>
MS21042L6	Nut	6 Ea (6 ea)	250-Packaging	<u>5004002</u>
NAS1149D0663J	Washer	18 Ea (18 ea)	250-Packaging	<u>5093765</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D212-664-201TRN	1	0	0
230-Crosstubes	D2940-1 <u>5079508(1)</u>	<u>2</u> 125887(1)	3	0
	D3595-063-530 <u>5108625</u>	<u>4</u>	17	0
	MS21920-28 <u>5100402</u>	<u>4</u>	61	0
250-Packaging	AN6-40A	4	63	0
	AN6-41A	2	45	0
	D3428-1	1	29	0
	MS21042L6	6	190	0
	NAS1149D0663J	18	1,362	0

Part Specifications

Specifications could not be found.

Plex 8/17/18 2:23 PM Dart.lajeunesse.marie



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Container No: S126100



Part: D212-664-201

Job No: 182139

Serial No/Batch: S126100

Revision: E/J

Inspector:

Exp Date:

Instructions: TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA ST

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

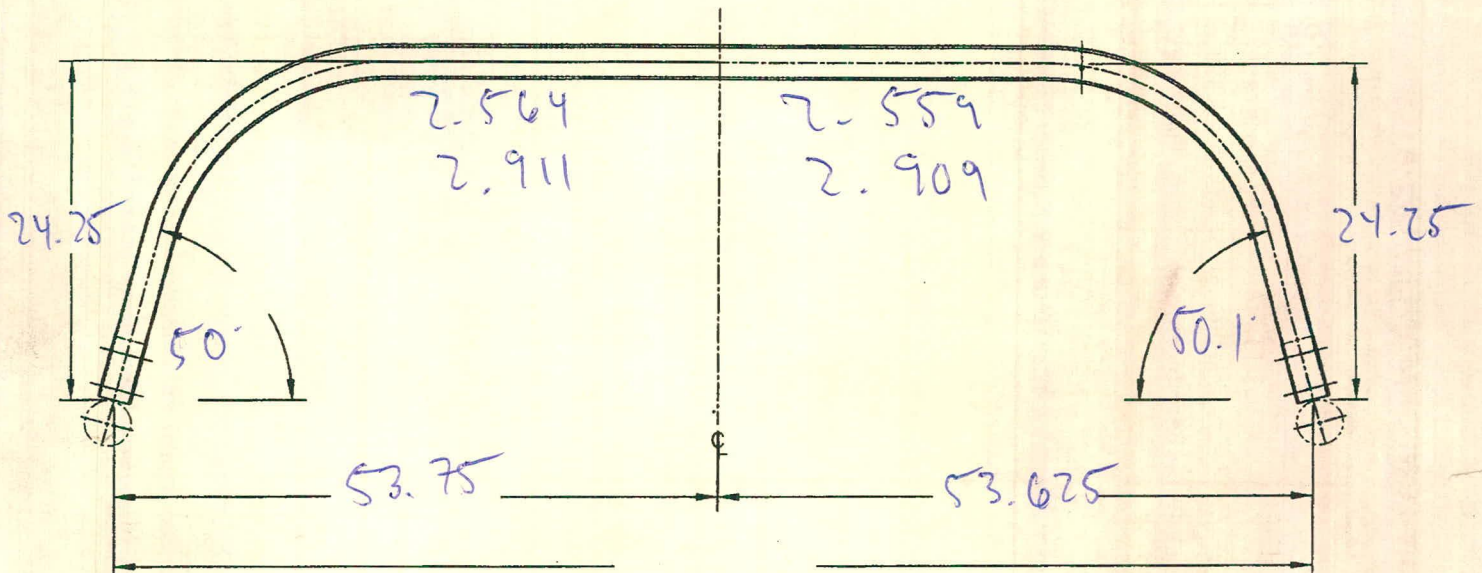
QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

DART AEROSPACE LTD		Work Order:	182139
Description: Crosstube High Aft (205/212)		Part Number:	D212-664-201
Inspection Dwg: D212-664-241 Rev: E		Page 1 of 1	

Required Dimension	Min	Max
Height	24.17	24.43
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.70
Bending Passes	5	--
Crushing	--	7.2%



	Side A	Side B
Bending Passes	17	17
Crushing	6.3%	6.4%
Comments		

QC15 Inspection	93
Date	18-11-12

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.08	Dimensions updated per Dwg rev. C	KJ/JLM	
C	10.04.01	Dwg Rev updated	KJ	
D	12.04.16	Added bending, crushing dimensions	KJ	
E	14.07.08	Crushing percentage revised	KJ	4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
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								Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Item	Qty -241	Qty -241B	Part Number	Description
1	X		D212-664-241	CROSSTUBE ASSEMBLY (205/212 HIGH AFT)
2		X	D212-664-241B	CROSSTUBE ASSEMBLY (214 HIGH AFT)
3	1	1	D6006-129	CROSSTUBE
4	2		D2940-1	SUPPORT
5	4	4	D3595-063-530	RUBBER CUSHION
6		2	D5018-1	SUPPORT
7	4	4	MS21920-28	CLAMP (OR MS21920-30)
8	A/R	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6006-129
FINISHED LENGTH = 124.362±0.020
- FINISH: a) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
b) PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
c) MASK UNDERSIDE OF CROSSTUBE AS SHOWN (ZN C6-2 / C6-3, HATCHED AREA)
d) PAINT OUTSIDE PER DART QSI 005 4.2
e) REMOVE MASKING AND APPLY MATTE CLEAR COAT
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- WEIGHT: D212-664-241/-241B = 44.2 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

MACHINING

- RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.

BENDING

- BEND PROGRESSIVELY WITH A MINIMUM OF 5 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 7.2% (BASED ON O.D.) IN LOWER HALF OF R35.5 BEND AND 6% (BASED ON O.D.) ON REMAINING TUBE.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.

ASSEMBLY

- INSTALL D2940-1 / D5018-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- INSTALL MS21920-28 CLAMPS (OR -30) WITH D3595-063-530 RUBBER CUSHIONS TO SECURE THE SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE ON TOP SIDE OF CROSSTUBE.
- TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 182139 u.s.
180817

RELEASED
2014-05-26

E	D5018-1 WAS D2940-1 (-241B), PROSEAL WAS MAGNOBOND, NOTE 2: ADD INSPECTION WINDOW, NOTE 11: ALLOW 7.2% CRUSH, NOTE 15: ADD 72HR CURE AND RETORQUE FOR PROSEAL, ADD SHEET 3, CLAMPS REVERSED TO PREVENT CHAFING (ZN B7-2, B7-3), BEND HEIGHT TOL. NOW 0.25 WAS 0.13 (C1-4), INCORP DEO D-1/-2	CP	14.04.01
D	REFORMAT/REVISE GENERAL NOTES/PART LIST; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; ADD -241B (ZN D4-2, B4-2); REMOVED REF & ADD TOLERANCES (ZN D8-3 & C4-3, C6-3 & A8-3); RELOCATED FLAG #6 PER PAR 08-046 (ZN A5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4	RF	09.09.30
C	REMOVE -1009 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	PH	07.03.08
B	ADD HOLES FOR COMPATIBILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	CP	00.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	14.04.01		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. E
D212-664-241 SHEET 1 OF 5
TITLE SCALE
CROSSTUBE ASS'Y (205/212 HI AFT) NTS

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DQA: _____ Date: _____

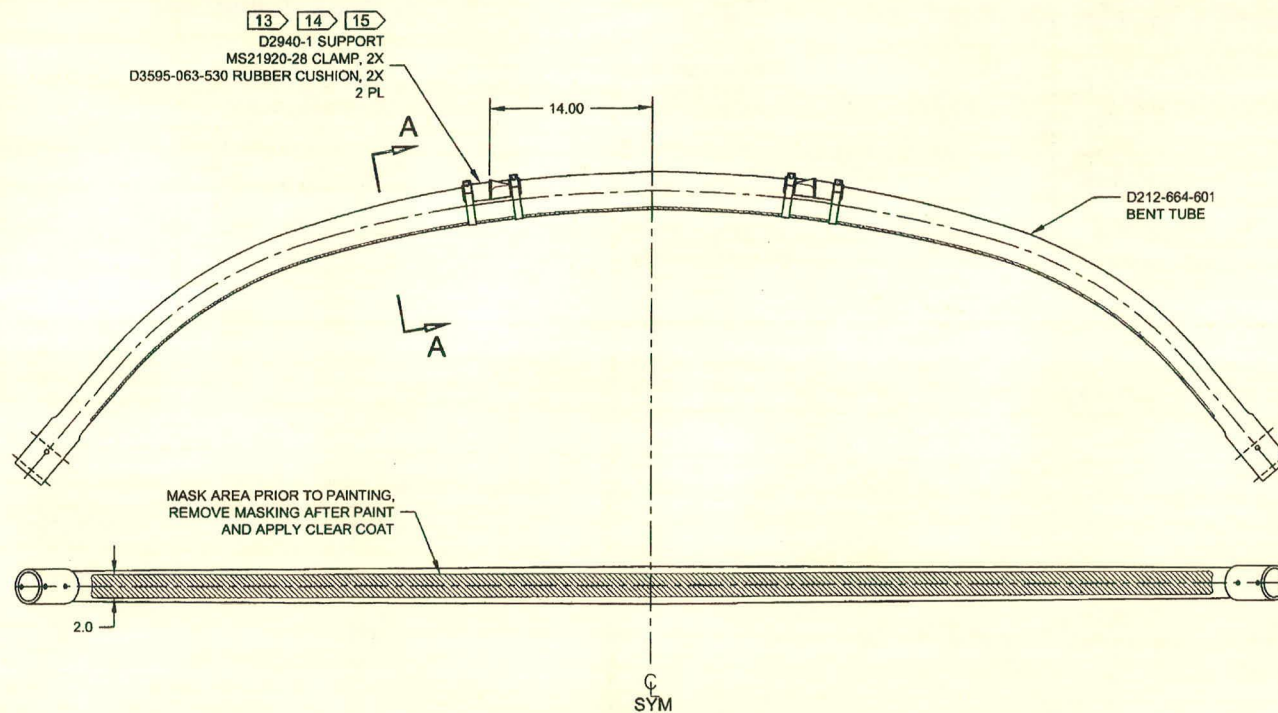


WORK ORDER NON-CONFORMANCE / UPDATE

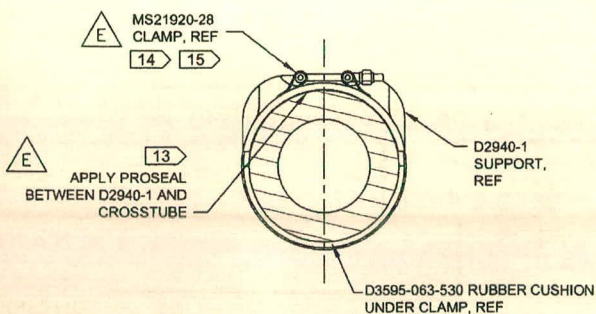
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Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							



**D212-664-241
ASSEMBLY DETAIL**



**SECTION A-A
SCALE 4X**

RELEASED
2014-05-26

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D212-664-241	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASS'Y (205/212 HI AFT)	NTS
DATE	14.04.01	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____

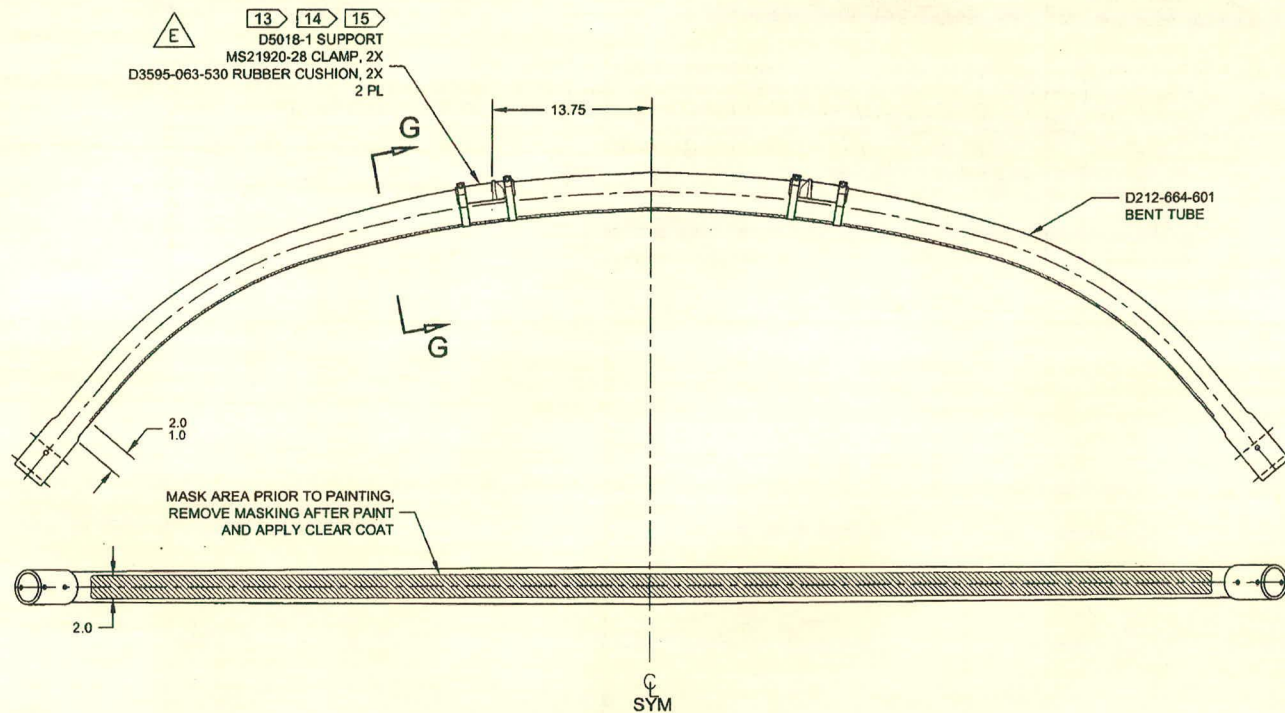


WORK ORDER NON-CONFORMANCE / UPDATE

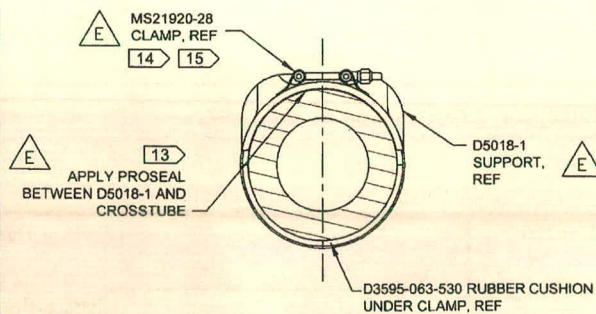
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							



**D212-664-241B
ASSEMBLY DETAIL**



**SECTION G-G
SCALE 4X**

RELEASED
2014-05-26

DESIGN	Q	DART AEROSPACE LTD	
DRAWN	Q	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DW	DRAWING NO.	REV. E
MFG. APPR.		D212-664-241	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASS'Y (205/212 HI AFT)	NTS
DATE	14.04.01	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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DQA: _____ Date: _____

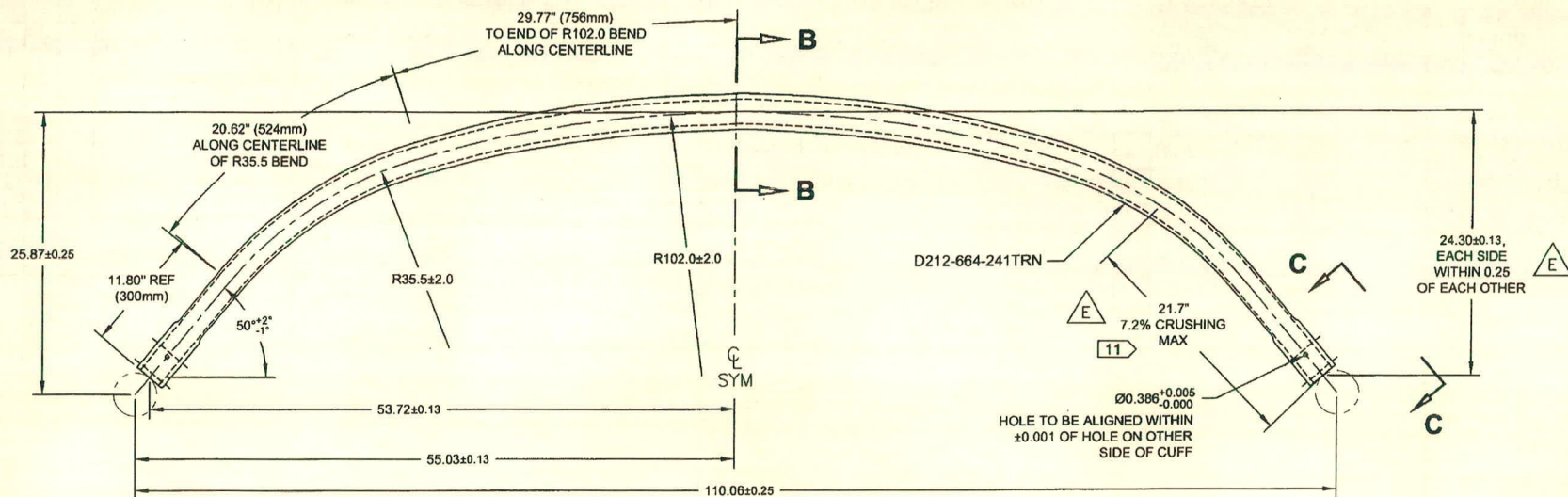


WORK ORDER NON-CONFORMANCE / UPDATE

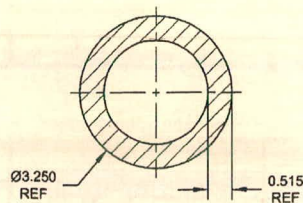
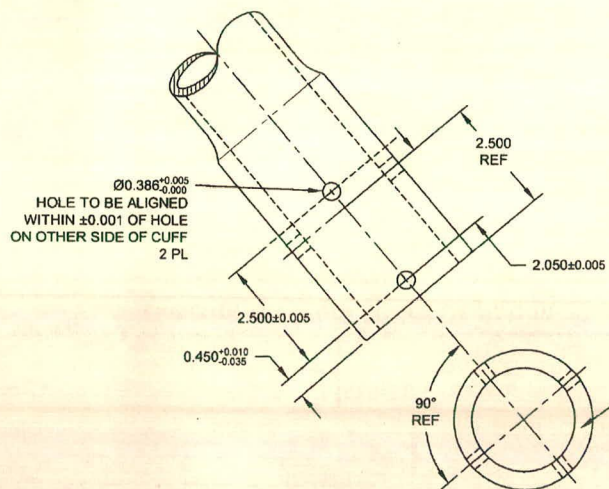
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							



D212-664-601 11
BENDING AND DRILLING DETAIL



RELEASED
2014-05-26
JMD

DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DL	DRAWING NO.	REV. E
MFG. APPR.		D212-664-241	SHEET 4 OF 5
APPROVED	AN	TITLE	SCALE
DE APPR.		CROSSTUBE ASS'Y (205/212 HI AFT)	NTS
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DQA: _____ Date: _____



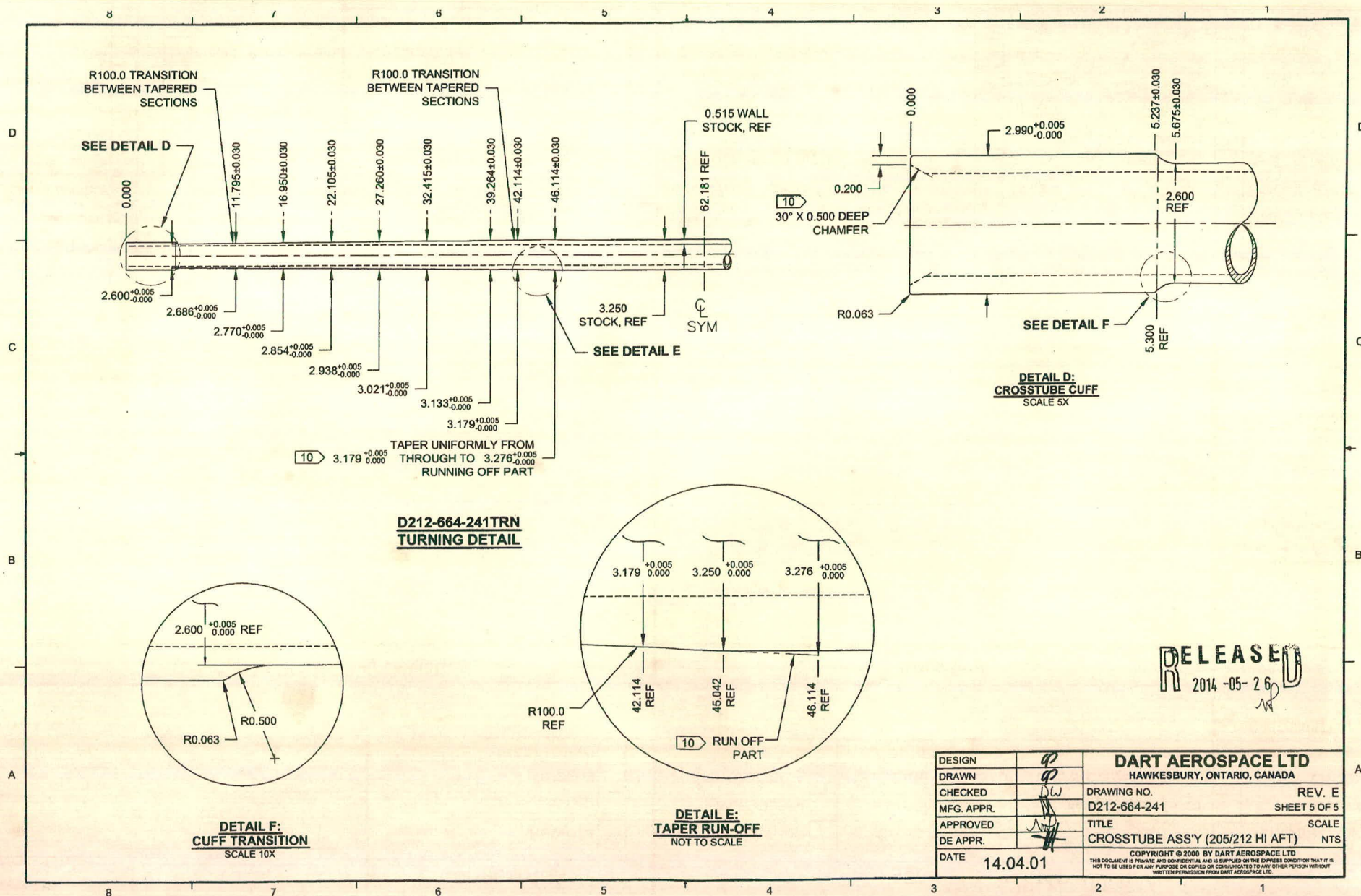
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :			
Misidentified	☐	Past Due	☐				



RELEASED
2014-05-26

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D212-664-241	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASS'Y (205/212 HI AFT)	NTS
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Root Cause <table style="width:100%; border: none;"> <tr><td style="border: none;">Environment ☐</td><td style="border: none;">No Re-verification ☐</td></tr> <tr><td style="border: none;">Design ☐</td><td style="border: none;">Operator ☐</td></tr> <tr><td style="border: none;">Doc/Data ☐</td><td style="border: none;">Offset/Setup ☐</td></tr> <tr><td style="border: none;">Equip/Tooling ☐</td><td style="border: none;">Supplier ☐</td></tr> <tr><td style="border: none;">Handling/Pre ☐</td><td style="border: none;">Training ☐</td></tr> <tr><td style="border: none;">Material ☐</td><td style="border: none;">Use for Testing ☐</td></tr> <tr><td style="border: none;">Internal Transport ☐</td><td style="border: none;">Poor Information ☐</td></tr> <tr><td style="border: none;">Tribal Knowledge ☐</td><td style="border: none;">Rushing ☐</td></tr> <tr><td style="border: none;">LOA ☐</td><td style="border: none;">Product Improvement ☐</td></tr> <tr><td style="border: none;">Substation ☐</td><td style="border: none;">Process Improvement ☐</td></tr> <tr><td style="border: none;">Past Expiry Date ☐</td><td style="border: none;">Manufacturing Process ☐</td></tr> <tr><td style="border: none;">Misidentified ☐</td><td style="border: none;">Past Due ☐</td></tr> </table>		Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	FAULT CATEGORY <table style="width:100%; border: none;"> <tr><td style="border: none;">Pressure/Forced ☐</td><td style="border: none;">Temperature/Cure ☐</td><td style="border: none;">Power Loss/Surge ☐</td><td style="border: none;">Positioned Wrong ☐</td></tr> <tr><td style="border: none;">Bending ☐</td><td style="border: none;">Set-up ☐</td><td style="border: none;">Folio/Program ☐</td><td style="border: none;">Outside Dimensions ☐</td></tr> <tr><td style="border: none;">Centre Not Concentric ☐</td><td style="border: none;">BOM/Route ☐</td><td style="border: none;">Grain ☐</td><td style="border: none;">Over/Under tolerance ☐</td></tr> <tr><td style="border: none;">Cracks ☐</td><td style="border: none;">Broken/Damage/Defect ☐</td><td style="border: none;">Weld ☐</td><td style="border: none;">Part Incorrect ☐</td></tr> <tr><td style="border: none;">Crimp/Kink/Ripple/Wave ☐</td><td style="border: none;">Inspection Incomplete/Unqualified ☐</td><td style="border: none;">Wrong Stock Pulled ☐</td><td style="border: none;">Part Lost/Missing ☐</td></tr> <tr><td style="border: none;">Cuffs ☐</td><td style="border: none;">Contamination ☐</td><td style="border: none;">Out of Sequence ☐</td><td style="border: none;">Part Moved ☐</td></tr> <tr><td style="border: none;">Crushing ☐</td><td style="border: none;">Countersink ☐</td><td style="border: none;">Off-set ☐</td><td style="border: none;">Drawing ☐</td></tr> <tr><td style="border: none;">Heat Treat ☐</td><td style="border: none;">Cut Too Short ☐</td><td style="border: none;">Mislabeled ☐</td><td style="border: none;">Finish ☐</td></tr> <tr><td style="border: none;">Wave/Twist in Tube ☐</td><td style="border: none;">Instructions Incomplete/Unclear ☐</td><td style="border: none;">Fit/Function ☐</td><td style="border: none;">Misread ☐</td></tr> <tr><td style="border: none;">Marks/Chatter ☐</td><td style="border: none;">Drill Holes ☐</td><td style="border: none;">Misaligned/off center ☐</td><td style="border: none;">Turning Sequence ☐</td></tr> </table>			Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
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OTHER :																																																																				



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041806**

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO041806
PO Date: 11/21/18
Due Date: 11/28/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	184457	D4884-3	End Fitting, Eye : Various STC's Outsource process - NDT per QSI038 4.1	Firmed	-	11/28/18 4 X	4 pcs	0 pcs	4 pcs	\$68.20/pcs	\$272.80
2	183453-A	D4884-1	End Fitting, Eye : Various STC's ISSUE P/O	Firmed	-	11/28/18 6 X	6 pcs	0 pcs	6 pcs	\$68.20/pcs	\$409.20
3	182141	D212-664-201	Aft Crosstube - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA-316/2015 15/06/17 ***WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE.*** Issue P/O: LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2	Firmed	-	11/28/18 1 X	1 pcs	0 pcs	1 pcs	\$68.20/pcs	\$68.20
	183771	1 X	NOV 2 3 2018	Firmed	-	11/28/18	1 pcs	0 pcs	1 pcs	\$68.20/pcs	\$68.20
	182139	1 X	NOV 2 3 2018	Firmed	-	11/28/18	1 pcs	0 pcs	1 pcs	\$68.20/pcs	\$68.20
	182142	1 X	NOV 2 3 2018	Firmed	-	11/28/18	1 pcs	0 pcs	1 pcs	\$68.20/pcs	\$68.20
Sub Total:							4	0	4		\$272.80



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041806**

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	186378	D212-664-101	Fwd Crosstube - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA-316/2015 15/06/17 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	11/28/18	1 pcs	0 pcs	1 pcs	\$68.20/pcs	\$68.20
										Grand Total: \$1,023.00	

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/21/18 3:28 PM dart.tsimiklis.chrisoula

**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO38261	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PQ041774
Descr:	PN:	S/N:	Qty: 1 P/O: 041806
Make:	Model:	Reg:	A/C S/N: 2 NOV 23 2018
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT (LIQUID PENETRANT CRACK TEST) ON THE FOLLOWING PARTS:

P/N: D4884-3 END FITTINGS, EYE JOB SHEET# 184457 (4 ea.) ✓

P/N: D4884-1 END FITTINGS, EYE JOB SHEET# 183453-A (6 ea.) ✓

P/N: D212-664-201 AFT CROSSTUBE - HIGH

JOB SHEET# 183771 ✓ JOB SHEET# 182141 ✓

JOB SHEET# 182139 ✓ JOB SHEET# 182142 ✓

P/N: D212-664-101 FWD CROSSTUBE - HIGH

JOB SHEET# 186378 ✓

Action Taken:						Date:	Initial/Stamp:
LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE AS PER ASTM1417M-16						20 NOV 2018	
NO CRACK FOUND							
PEN (ZL-56, MPO13600), DEV. (SKD-S2, MPO11715), CLEANER (SKC-S, MPO19368)							
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp 	Date: 20 NOV 2018
Name: CHRISTIAN BRIEN		

